

Work Order ID 137157-2

Thursday, September 24, 2015 2:11:00 PM

137157

Page 1

Item ID: D4776-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Clevis

Start Date: 9/23/15

Start Qty: 10.00 *10*

Required Date: 9/23/15

Req'd Qty: 10.00 *10*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MJS

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4776

D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.400"

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB168

DWG REV: D

FOLIO REV: AA

2- deburr and break all sharp edges

DAS

20

9-89

15-10-30

Work Order ID 137157

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Page 2

Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Clevis
 Start Date: 9/23/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		A 15/11/02		8	φ		DAS 20 15-10-30 9-89
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	φ		DAS 40 15/11/02 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8	φ	15-11-2	DAS 34 9-89

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8

DAS
\$8
9-89

NOV 04 2015

Work Order ID 137157

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Page 4

Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Clevis

Start Date: 9/23/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>St 124</u>	0.00				<u>8</u>	<u>15/11/4</u>	<u>sd</u>	
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Signature 0951506

Picklist Print

Thursday, September 24, 2015 2:10:59 PM

Page 1

Work Order ID: 137157

137157

Parent Item: D4776-3

D4776-3

Parent Item Name: Skidtube Clevis

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM
REV:B 13.09.26 AS PER REV.B DD VERF:JLM
PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM
IPP
IPP REV:C AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased		No		100	f	12.1200	0.367	3.863158			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

**

15/10/28

Location

Loc Qty

Loc Code

MAT004

12.12

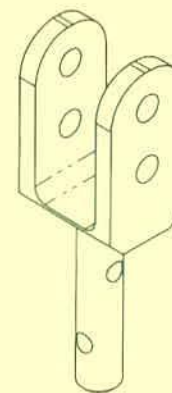
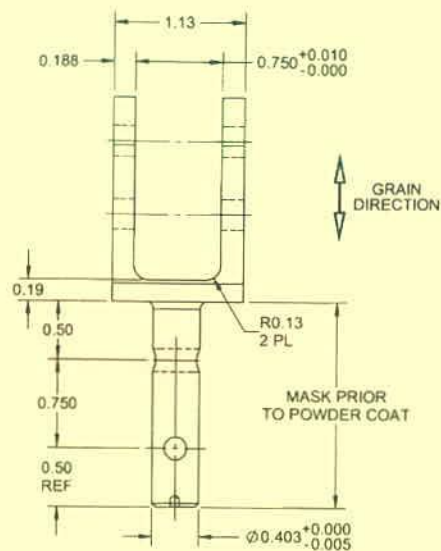
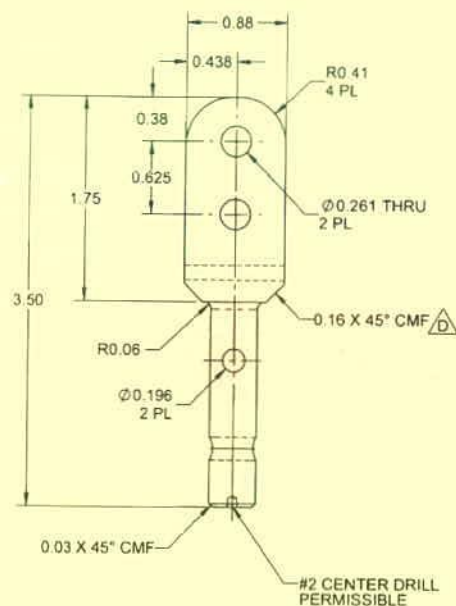
m128980

0.12

m129666

12

9,328



RELEASED
2014-07-30

D4776-1 BASKET STRUT CLEVIS

NOTES:

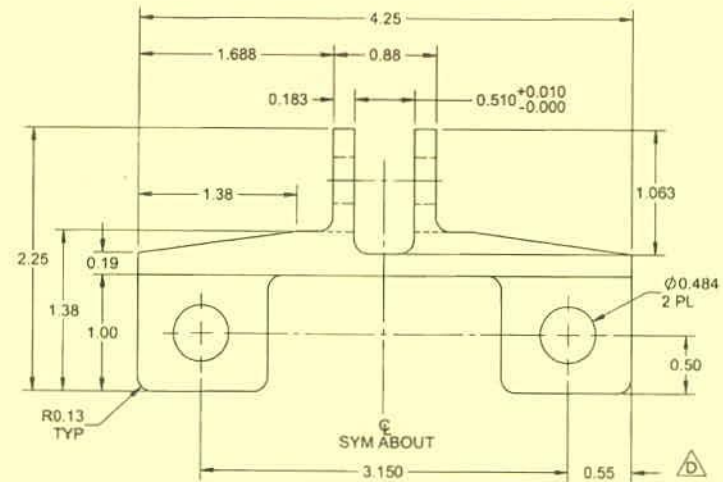
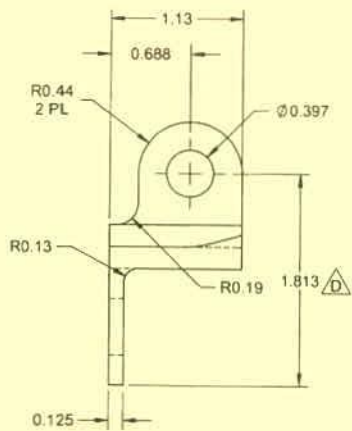
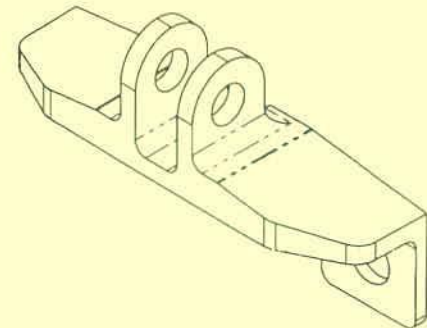
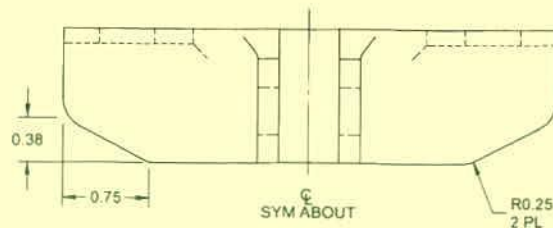
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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ORDER
137157 MLD
150925

D	SHT 1, C6 CHAMFER ADDED. SEE PAR 14-353. SHT 2, ZONE B2 1.513 DIM ADDED FOR CLARITY. ZONE B3 0.53 DIM CORRECTED TO 0.55 DUE TO DESIGN ERROR. SEE PAR 14-326.	AJS	14.07.14
C	SHT 2, C7, 1.13 DIM WAS 0.88. C8 0.688 WAS 0.438. ADDED TOP VIEW WITH CHAMFERS. REASON: INTERFERENCE WITH OEM SADDLES.	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS. INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°. FINISH ADDED TO -1. TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED. ADDED -5. REASON: EASE OF INSTALLATION. C3-2 DEPTH DIM ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR CONTAINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



GRAIN
DIRECTION

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2014-07-30

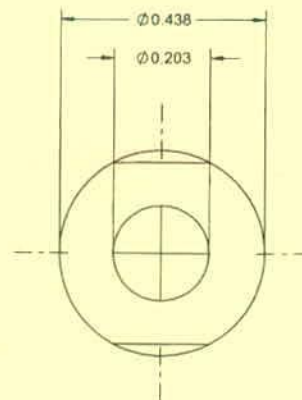
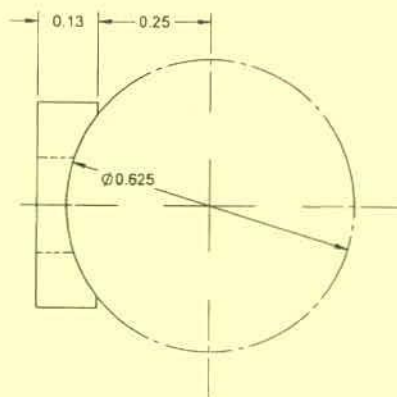
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. D
MFG. APPR.	<i>[Signature]</i>	D4776	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET STRUT MACHINED PARTS	NTS
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8 7 6 5 4 3 2 1



D4776-5 SPACER



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4776-5" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

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2014-07-30

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CHECKED	<i>[Signature]</i>	DRAWING NO. D4776	REV. D
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	BASKET STRUT MACHINED PARTS	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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